Vvork	Orde	er ID	61821

Page 1

Tuesday, September 07, 2010 12:46:29 PM Item ID: D4101-5 Accept Setup Start **Revision ID:** Stop Item Name: Spring **Start Date:** 9/7/2010 **Start Qty: 20.00 Cust Item ID:** Req'd Qty: 20.00 **Required Date: 10/13/2010 Customer:** Reference: Run Start Date:/0-9-07 Process Plan: Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation **Tool ID** Tool # Plan Reject Reject Set Up/ Accept Insp. **Work Center ID** Description Qty Qty Stamp Code **Run Hours** Number **Draw Nbr Revision Nbr** D4101 В 100 0.00 FLOW WATER JET 1310-9-02 Wateriet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D4101 Dwg Rev:\_\_\_\_\_\_\_ LEXAN Prog Rev: 4510/09/22 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1B 10-9-27 QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 8 10/09/23 Memo Quality Control

W/O:		- Pro-	W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	e Qty	Approval Chief Eng /	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Ye	s No	DQA:	_ Date: _	
	Re	esolution:	Dispositi	on:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NO	R)			
		Description of NC		Corrective Action Secti		Ve	rification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	1 &	Section C	Chief Eng	QC Inspector
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Page 2

Tuesday, September 07, 2010 12:46:29 PM Item ID: D4101-5 Accept Setup Start **Revision ID:** Stop Item Name: Spring Start Qty: 20.00 **Start Date:** 9/7/2010 **Cust Item ID:** Req'd Qty: 20.00 **Required Date:** 10/13/2010 **Customer:** Reference: Run Start Process Plan: Date: Tooling: Approvals: Date: Stop QC: Date:\_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Accept Reject Insp. Description **Work Center ID Run Hours** Code Qty Qty Number Stamp Form as per dwg 130 NC BRAKE N/A 1/2 10.00,22 Brake NC Memo Brake NC 140 QC5- Inspect part completeness to step on W/O QC Memo Quality Control Identify as per dwg & Stock Location 7/27 150 0.00

Packaging Packaging

Memo

0.00

W/O:			WO	RK ORDER CHANGE	S			
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes N	No DQA: _	Date: _	
	Res	olution:	Disposition	n:	QA: N/C Clo	sed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Corrective Action		Section B		on Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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				·				

#### Work Order ID 61821

**Required Date:** 10/13/2010

Tuesday, September 07, 2010 12:46:29 PM



Page 3

Item ID:

5 .

D4101-5

Accept



Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

Spring

9/7/2010

QC:

**Start Qty: 20.00** 

Req'd Qty: 20.00



Date:\_\_\_\_\_

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** SPC (Y/N):

Date:

Tool ID

Date:

Tool # Plan

Code

Start

Run

Accept

Qty

Stop

Reject

Qty

Sequence ID/

**Work Center ID** 

160

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

0.00

Reject Number

Insp. Stamp

Memo

0.00

Quality Control

W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Dat	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	s No	DQA:	Date: _	
	R	esolution:	Disposition	າ:	QA: N/C	Closed	:	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section			v	erification	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat		Section C	Chief Eng	QC Inspector
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### **Picklist Print**

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Tuesday, September 07, 2010 12:46:35 PM

Work Order ID: 61821

Parent Item: D4101-5

Parent Item Name: Spring



Start Date: 9/7/2010

Required Date: 10/13/2010

Page 1

**Start Oty: 20.00** 

Required Oty: 20.00

Comments:

IPP Rev: A 10.07.07 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
1217137	*     <b>     </b>	Purchased	No	-		100	sf	0.0000	0.0119	0.238	3		
										1B10	-9-22		

301-59-048 sheet

115 621

MLEXS.125-F60029-04

grey Lexan sheet .125" thick

MLO,09.08

Mess. 18 F60089-04

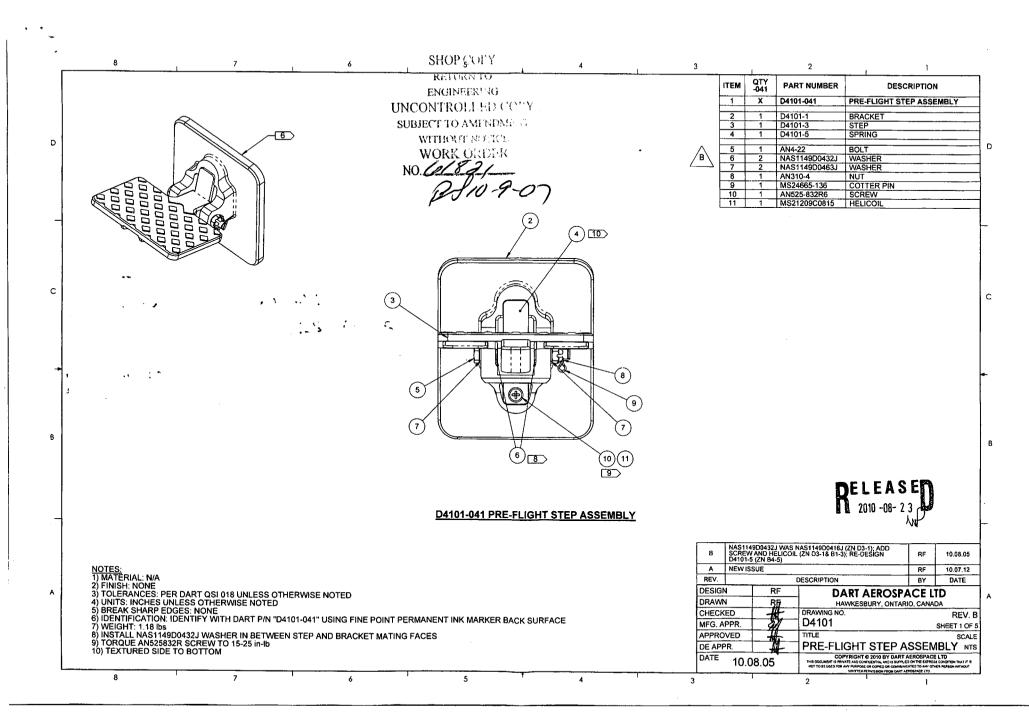
W/O:			W	ORK ORDER CHANG	ES				٠,
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvai QC Inspector
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Part No	•	PAR #:	Fault Cate	egory:	NCR: Ye	s No D	DQA:	Date: _	
		esolution:							
NCR:		\	WORK ORD	ER NON-CONFORM	ANCE (NO	CR)			***
DATE STEP		Description of NC	on of NC Corrective Action			ection B Verification			Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da		ection C	Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	61821
Description: Copins	Part Number:	D4101-5
Inspection Dwg: Dt(0)-5 Rev: B		Page 1 of 1

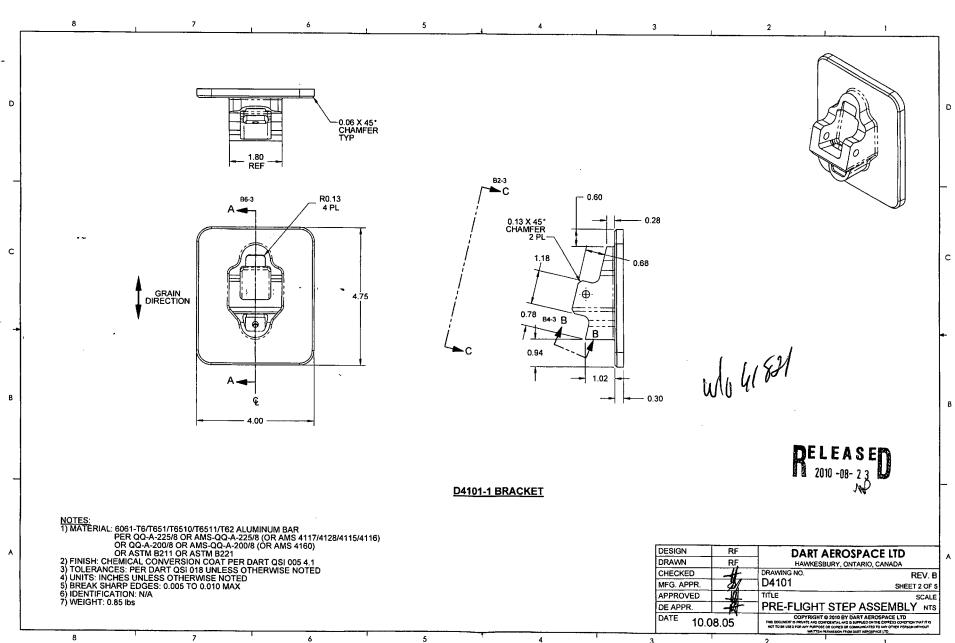
# FIRST ARTICLE INSPECTION CHECKLIST

	x	First Artic	cle _	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	nents
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Measured b	y: 1B	Audited by:	: [2]		Prototype App		N/A
	0 0 5	Date	in/s/	)7	Date: N/A		N/A

	Date:	10-9-87	Date: 10/09/03	Pate: N/A
			Revise	ed by Approved
Rev	Date	Change	KJ/JLN	1
Α		New Issue	1000	



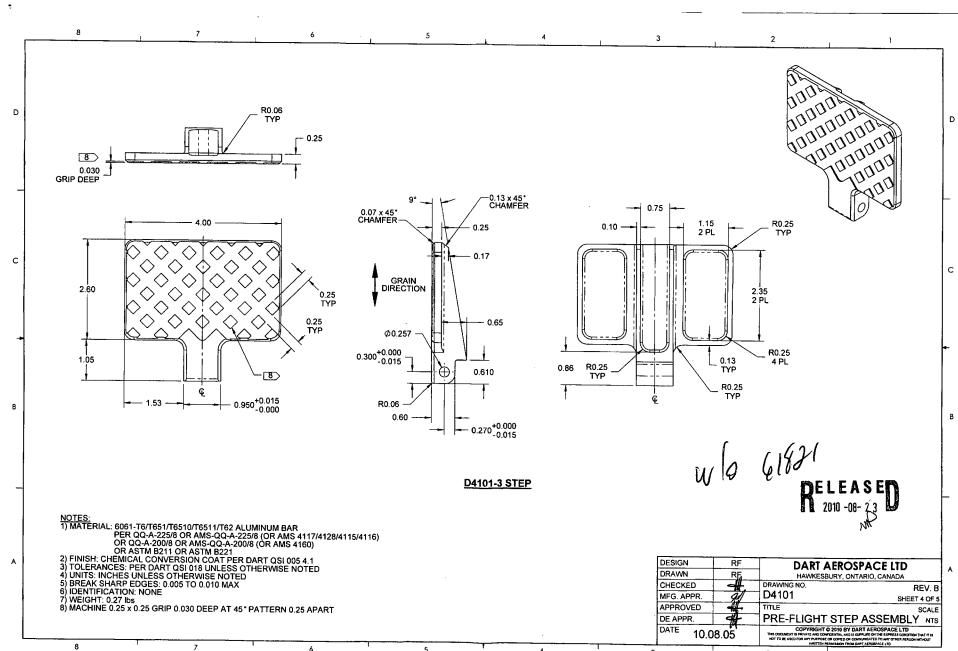
W/O:			W	ORK ORDER CHANG	ES		·		*
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Park							
Part No		PAR #:							
	Res	solution:						Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section		Sign & Verification Section C			Approval
	0.2.	Section A	Chief Eng	Action Description Chief Eng	Date	Sec	tion C	Chief Eng	QC Inspector



W/O:			WO	RK ORDER CHANC	GES					•
DATE	STEP	PR	OCEDURE CHAP	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NCF	R: Yes	No <b>DQ</b>	A:	Date:	
	Re	esolution:	Disposition	:	QA:	N/C CId	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR	)	•		
DATE	STEP	STED Description of NC	Corrective Action Section B			0:		cation	Approval	Approval
DAIL	0,0,	Section A	Initial Action Descrip Chief Eng Chief Eng			Sign & Date		ion C	Chief Eng	QC Inspector
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	] ]						1			

D R0.25 2 PL R0.500 0.075 TYP Ø0.257 2 PL 0.950 R0.13 0.350 8 PL 1.05+0.03 R0.06 TYP 0.49 0.850 С 0.350 0.38 REF 0.400 0.255 \_\_ R0.38 0.286 R0.06 R0.13 4 PL 4 PL 1.00 2 PL REF -DRILL & TAP FOR 8-32 HELICOIL Ø0.177 DRILL 0.40 DEEP & TAP 0.30 DEEP 0.51 0.670 0.40 2 PL SECTION A-A C7-2 VIEW B-B C4-2 SCALE 2X VIEW C-C D4-2 SCALE X1.5 RELEASED 2010 -08- 2-3 who here DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN RĘ CHECKED DRAWING NO. REV. B D4101 MFG. APPR. SHEET 3 OF 5 APPROVED TITLE SCALE PRE-FLIGHT STEP ASSEMBLY TO NESSEMBLY TO THE CONFIDENCE OF THE CON DE APPR DATE 10.08.05

W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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			···							
Part No	•	PAR #:	Fault Categ	ory:	_ NCR: Yes	No <b>DQ</b> A	<b>\</b> :	_ Date: _		
			Disposition	Disposition: QA: N/C Closed: Dat						
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	3)				
DATE	STEP	Description of NC		Corrective Action Section		verification			Approval	
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W/O:			W	ORK ORDER CHANG	GES					
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Part No: PAR #:		Fault Category: NO			NCR: Yes No DQA: Date: _					
Resolution:					QA: N/C Closed:				Date:	
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DATE	STEP	Description of NC		ction B	VARITIA			cation Approval	Approval	
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C		Chief Eng	QC Inspector
						.				

- Ø0.177 **1** С 0.65+0.00 0.325 REF 237 R0.13 TYP 0.125 0.238 - 2.68<sup>+0.00</sup> .149 **D4101-5 SPRING** W/o 41821 NOTES:
1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK REF DART SPEC MLEXS.125-F60029-04 REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.01 lbs DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN RF CHECKED DRAWING NO. REV. B D4101 MFG. APPR. SHEET 5 OF 5 APPROVED TITLE PRE-FLIGHT STEP ASSEMBLY NTS DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE					Date (	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #:	Fault Category: N			NCR: Yes No DQA: Date:						
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NCR:			WORK ORDI	R NON-CONFORM	ANCE (N	CR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Veri			Approval	al Approval		
			Initial Chief Eng	Action Description Chief Eng	Sig Da	n & ite	Section		Chief Eng	QC Inspector		
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